

Work Order ID 149626

July 25, 2016 3:57:21 PM

149626

Order to ship
July 29th Page 1

Item ID: D2332-043

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Item Name: Lid Prop Assembly 8.00"

Stop

NS2

Start Date: 7/25/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/2/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: SB

Date: 7/25/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2332	Rev C1

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut to length as per Dwg D2332 (D2332-7) Locking CollarCut to length as per Dwg D2332 (D2332-5) Stop Pin Deburr

DAS
30
9-89

2

JUL 26 2016

110

0.00

110

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012(Note: Make (2) D2332-11 Prop Arms per assembly.)

DAS
30
9-89

2

JUL 26 2016

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill hole in D2332-1 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)2-ensure no foreign objects inside fo tube and deburr

DAS
30
9-89

2

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER :																									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID 149626

149626

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Item ID: D2332-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lid Prop Assembly 8.00"
Start Date: 7/25/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/2/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
160									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							DAS 30 9-89
170									
Small Fab	Memo	0.00							
Small Fab	Tumble and Deburr								
180	Small Fab	0.00							JUL 29 2016
180									
Small Fab	Memo	0.00							
Small Fab	1-Tumble2-Assemble as per Dwg D2332								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 149626

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Item ID: D2332-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lid Prop Assembly 8.00"
 Start Date: 7/25/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/2/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00				(2)			DAS 38 9-89
190									
QC	Memo	0.00							

Quality Control

JUL 29 2016

200	Identify as per dwg & Stock Location: <u>51367</u>	0.00							
200									
Packaging	Memo	0.00							DAS 6 9-89

Packaging

JUL 29 2016

210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							

Quality Control

16/08/03

DAS
21
9-89
AUG 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

July 25, 2016 3:57:25 PM

149626

D2332-043

Required Date: 8/2/2016

Required Qty: 2.00

Comments: IPP: B03.07.08Re-issue 8.00"" longKJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR1.000W.049		Purchased	No			100	f	46.7501	0.4219	0.888211			
M304TR1 000W 049										**	DAS		JUL 26 2016
304 RD Tube 1.00 x .049W											30		
											9-89		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA002				46.750079					
					125250			32.250031					
					m130551			14.500048					
MS21042L4		Purchased	No			100	Each	2,733.000	1	2			
MS21042L 4										**	DAS		JUL 29 2016
Locknut											30		
											9-89		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				51					
					m133363			51					
				GA				156					
					m133769			156					
				OVER007				2000					
					m135127			1000					
					m135297			1000					
				ST3003				26					
					m134955			26					
				ST303				500					
					m135058			500					

Picklist Print

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Page 2

Work Order ID: 149626

149626

Parent Item: D2332-043

D2332-043

Parent Item Name: Lid Prop Assembly 8.00"

Start Date: 7/25/2016

Required Date: 8/2/2016

Start Qty: 2.00

Required Qty: 2.00

M304R.250 Purchased No

110 f 12.0000 0.1083 0.228

M304R 250

304 SS Round bar .250

****** DAS
30
9.89

JUL 26 2016

Location

Loc Qty

Loc Code

MAT028

12

m135249

12

228

AN4-4A Purchased No

180 Each 133.0000 1

AN4-4A

BOLT

****** DAS
30
9.89

JUL 29 2016

Location

Loc Qty

Loc Code

FP001

6

m129390

6

ST346

127

m129390

127

2 DAS

AN960JD416L NAS1149D0416J Purchased No

180 Each 0.0000 3

***AN960JD416I ***

Washer

M304TR0.500W.035

Purchased No

M304TR0 500W 035

304 RD Tube .500 x .035W

M 131 516

180 f 149.2788 1.6666 3.508632

****** DAS
30
9.89

JUL 29 2016

****** DAS
30
9.89

JUL 26 2016

Location

Loc Qty

Loc Code

GA

15.45679

m133509

15.45679

GA002

133.8220434

m132872

1.6822064

m133611

3.994895

m134504

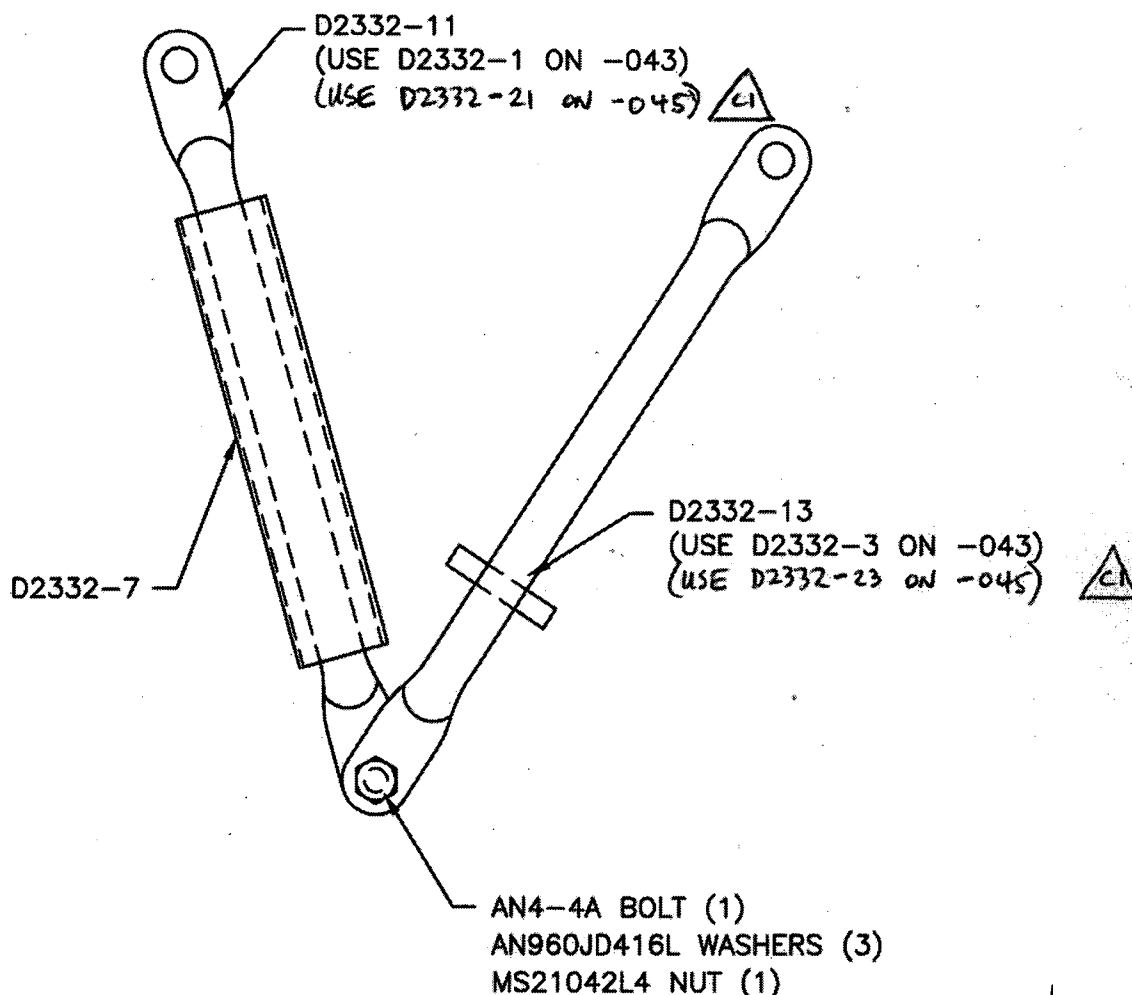
128.144942

3.51



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	# 40 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR)

7/25/16 SA
149 626

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